



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

D2885

Job Sheet 174969



Part No: D2885

Job Qty: 24 ea

Part Name: Saddle Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/23/18

Job Tracking No:

Due Date: 3/30/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV B IPP A 99.10.12 New Issue EC IPP Rev:B Now 6060-T6 06-06-23 JLM IPP Rev:C waterjet 06-07-23 ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea	3/29/18	3/29/18	0.00	0.00	Start Up Waterjet		DL 18/03/24
100	Waterjet	24 pcs	3/29/18	3/29/18	0.00	0.36	Waterjet1		DL 18/03/24
110	QC	24 pcs	3/29/18	3/29/18	0.00	0.00	QC2 Waterjet-1		DL 18/03/24
120	QC	24 pcs	3/29/18	3/29/18	0.00	0.00	QC8-1		38
130	HandFinish	24 pcs	3/30/18	3/30/18	0.00	0.14	HandFinish1		SAB 18-03-27
140	QC	24 pcs	3/30/18	3/30/18	0.00	0.00	QC7-1		11
150	Packaging	24 pcs	3/30/18	3/30/18	0.00	0.00	Packaging3		5/013
160	QC21-SA	24 Ea	3/30/18	3/30/18	0.00	0.00	QC21		APR 01 2018

Part Op 100 - 1-Cut as per Dwg D2885 Dwg Rev: B Prog Rev: B 2-Deburr if necessary

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Chemical Conversion Coat per QSI005 4.1

140 - QC7-Inspect Chemical Conversion Coat

150 - Identify as per dwg & Stock Location:

160 - QC21- Final Inspection - Work Order Release

DAS 21 9-89
APR 02 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	.6168 sf (.0257 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.080	1	168	0

CART
AEROSPACE

Container No: S054580



Part: D2885

Job No: 174969

Serial No/Batch: S054580

Revision:

Inspector:

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CANADA
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Date: 03/24/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle Spacer	0.430Inches $\pm$ 0.030	0.460 0.400		
2	Saddle Spacer	0.443Inches $\pm$ 0.010	0.453 0.433		
3	Saddle Spacer	0.257Inches $\begin{matrix} + 0.006 \\ - 0.001 \end{matrix}$	0.263 0.256	Diameter	
4	Saddle Spacer	0.300Inches $\pm$ 0.030	0.330 0.270	Radius	
5	Saddle Spacer	0.679Inches $\pm$ 0.010	0.689 0.669		
6	Saddle Spacer	0.400Inches $\pm$ 0.030	0.430 0.370	Radius	
7	Saddle Spacer	0.250Inches $\begin{matrix} + 0.030 \\ - 0.000 \end{matrix}$	0.280 0.250		
8	Saddle Spacer	0.672Inches $\pm$ 0.010	0.682 0.662		
9	Saddle Spacer	0.521Inches $\pm$ 0.010	0.531 0.511		
10	Saddle Spacer	1.340Inches $\pm$ 0.010	1.350 1.330		
11	Saddle Spacer	2.681Inches $\pm$ 0.010	2.691 2.671		
12	Saddle Spacer	3.710Inches $\pm$ 0.030	3.740 3.680		
13	Saddle Spacer	0.380Inches $\pm$ 0.030	0.410 0.350	Radius	
14	Saddle Spacer	0.528Inches $\pm$ 0.010	0.538 0.518		
15	Saddle Spacer	0.080Degrees $\pm$ 0.500	0.580 (0.420)	Angle	

Plex 3/23/18 11:19 AM Dart.Gagnon.Michelle